

# Work Order ID 54690

December 16, 2009 10:50:09 AM

Page 1

Item ID: D3891-4

Accept

Setup Start

Revision ID:

Item Name: Gasket

Stop

Start Date: 12/16/09 Start Qty: 1.00

Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-12-16

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3891

A

0.00

100



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3891

Dwg Rev: A

Prog Rev: H

2-Deburr if necessary

B 9-12-16

①

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B 9-12-16

# Work Order ID 54690

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Page 2

Item ID: D3891-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



=> Serial 16

QC

Memo

0.00

Quality Control



130

Identify as per dwg & Stock Location GA

0.00



8 09/12/17

Packaging

Memo

0.00

Packaging



140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10.01-06  
10.05

12/09-12-18  
①

# Picklist Print

December 16, 2009 10:50:08 AM

Page 1

Work Order ID: 54690

Parent Item: D3891-4

Parent Item Name: Gasket

Comments:

Start Date: 12/16/09

Required Date: 12/18/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M4111NS.125		Purchased	No			100	sf	322.3414	3.1189			

  
4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

112335

322.3414

322.3414

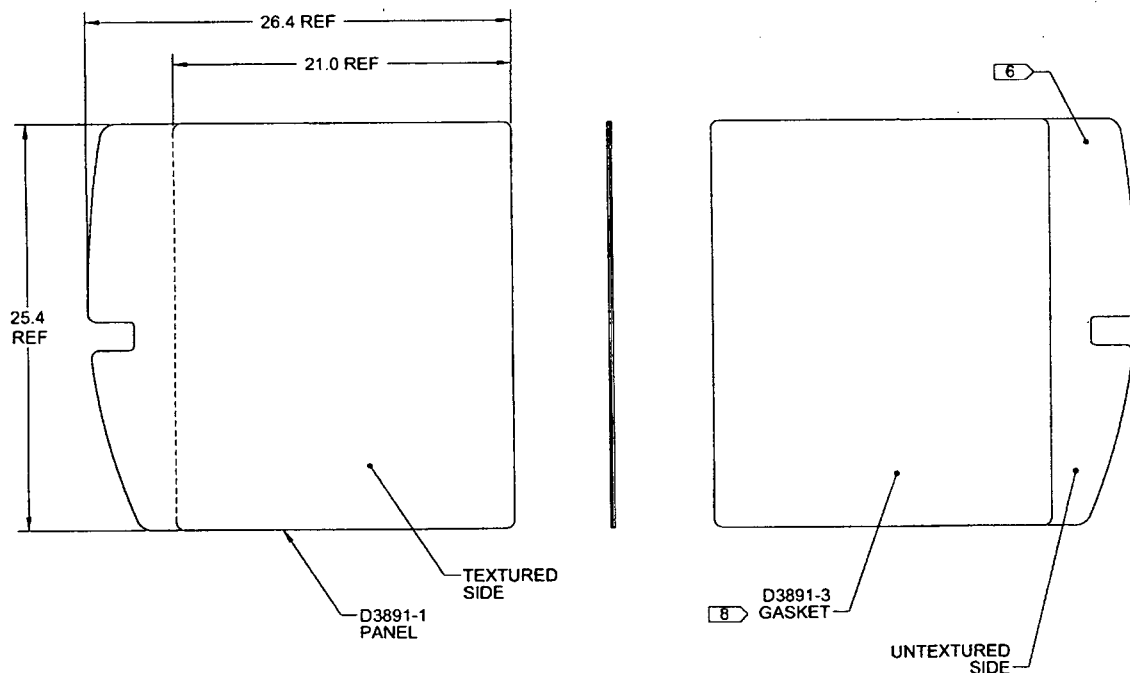
189-12-16

①

112335

## PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3891-041 PANEL, FWD LH**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: NONE
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
  - 7) WEIGHT: 3.67 lbs
  - 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54690

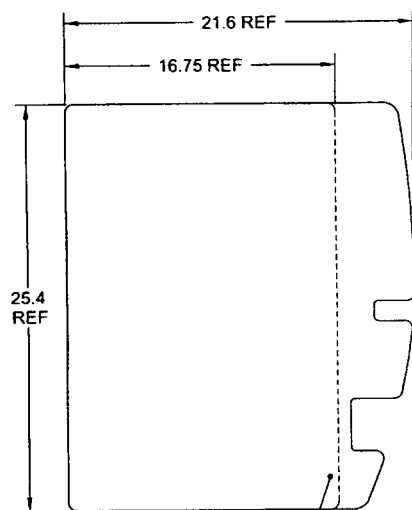
*09-12-16*

**RELEASED**  
C9/06/16 N/A

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>GP</i>	DRAWING NO. REV. A	
CHECKED	<i>RP</i>	D3891 SHEET 1 OF 6	
MFG. APPR.	<i>RP</i>	TITLE SCALE	
DE APPR.	<i>RP</i>	PANEL, FWD NTS	
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

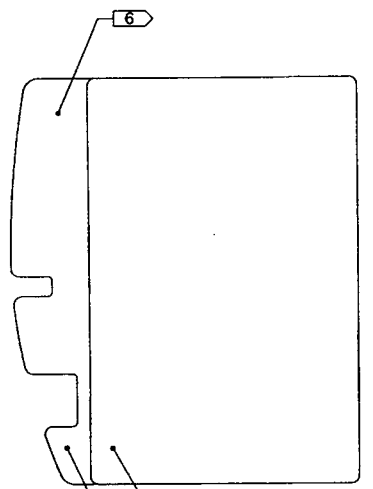
## PARTS LIST

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE

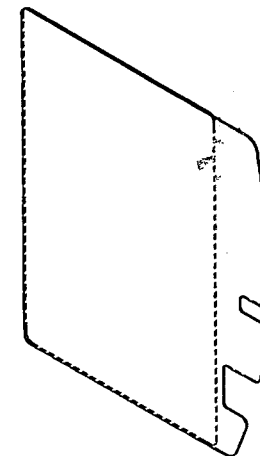


D3891-2 PANEL

TEXTURED SIDE

**D3891-042 PANEL, FWD RH**

D3891-4 GASKET 8

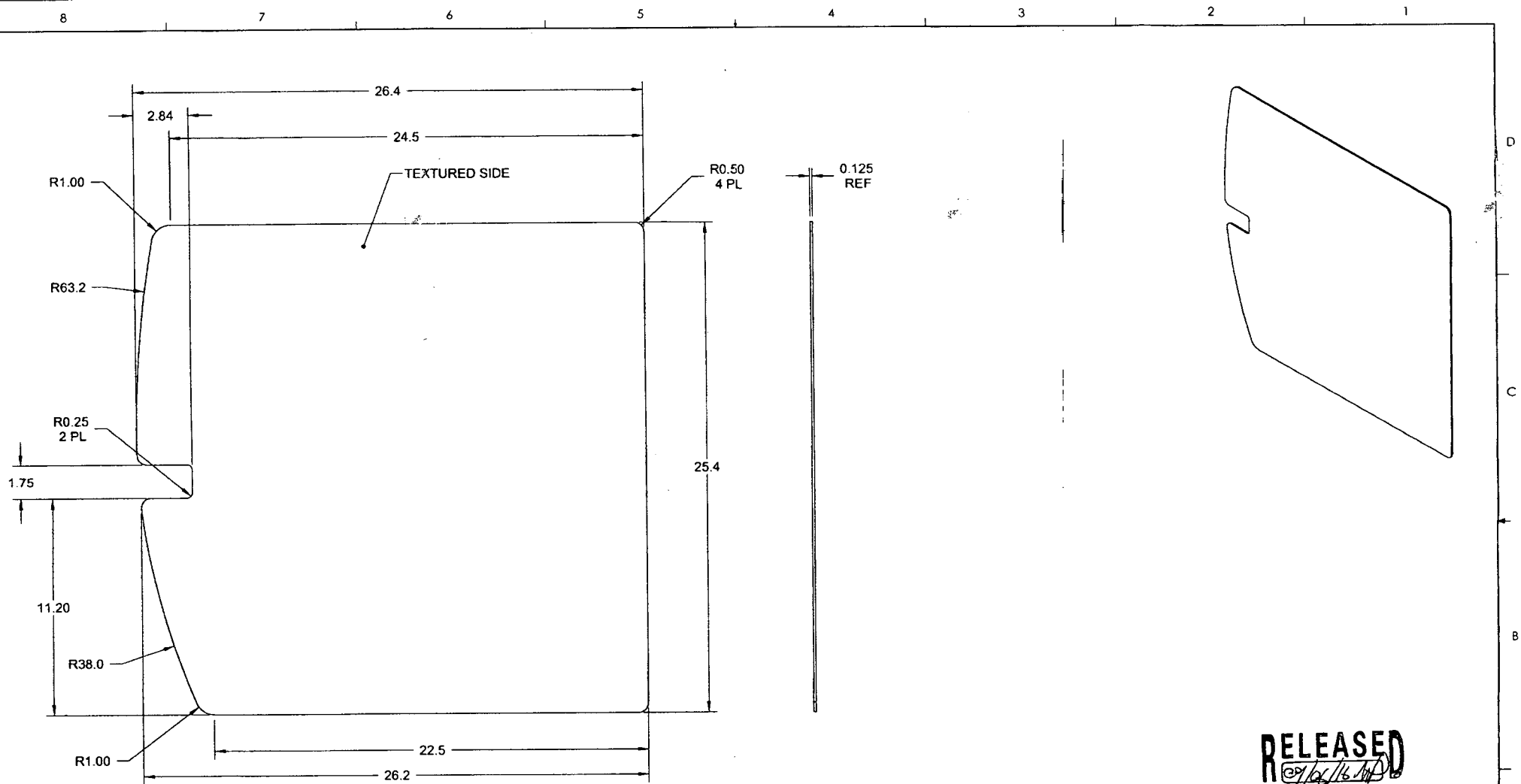
UNTEXTURED  
SIDE

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

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09/05/01

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CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	SP	D3891	SHEET 2 OF 6
APPROVED	SP	TITLE	SCALE
DE APPR.	SP	PANEL, FWD	NTS
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**D3891-1 PANEL**

**NOTES:**

1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

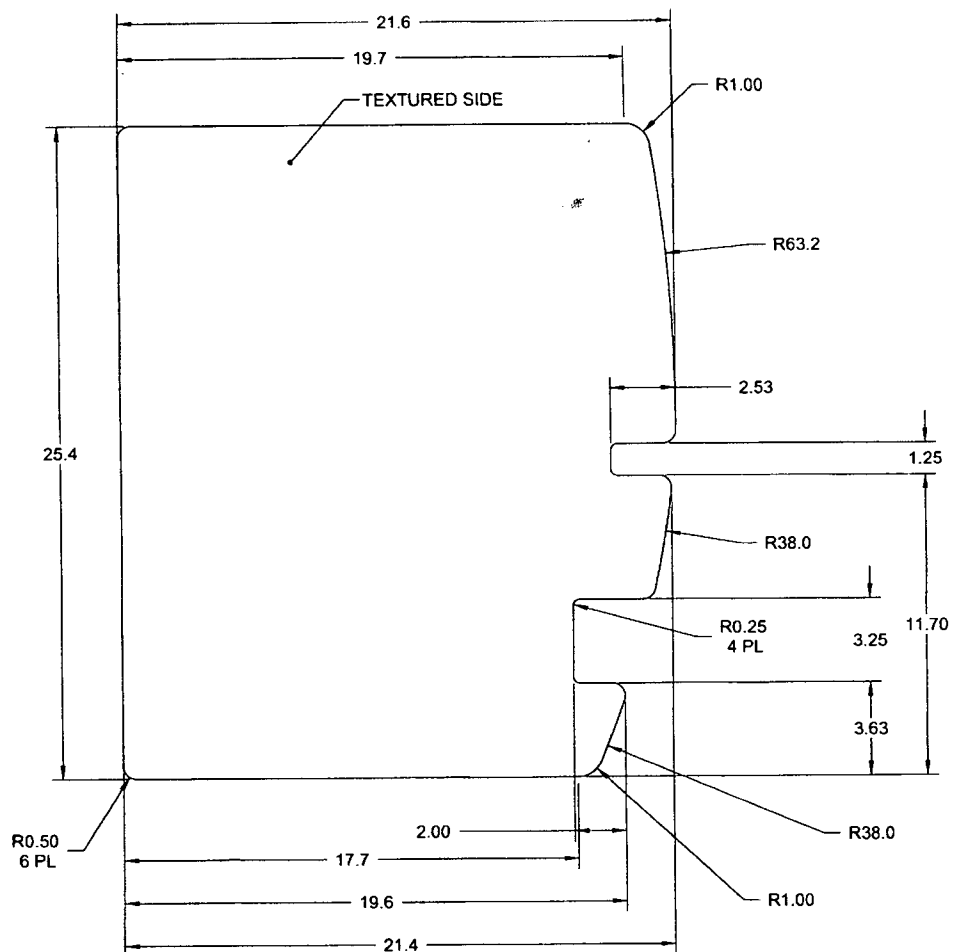
6) IDENTIFICATION: NONE

7) WEIGHT: 3.46 lbs

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09/05/01

W/D 54690

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CHECKED	DP	DRAWING NO.	REV. A
MFG. APPR.	DP	D3891	SHEET 3 OF 6
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	PANEL, FWD	NTS
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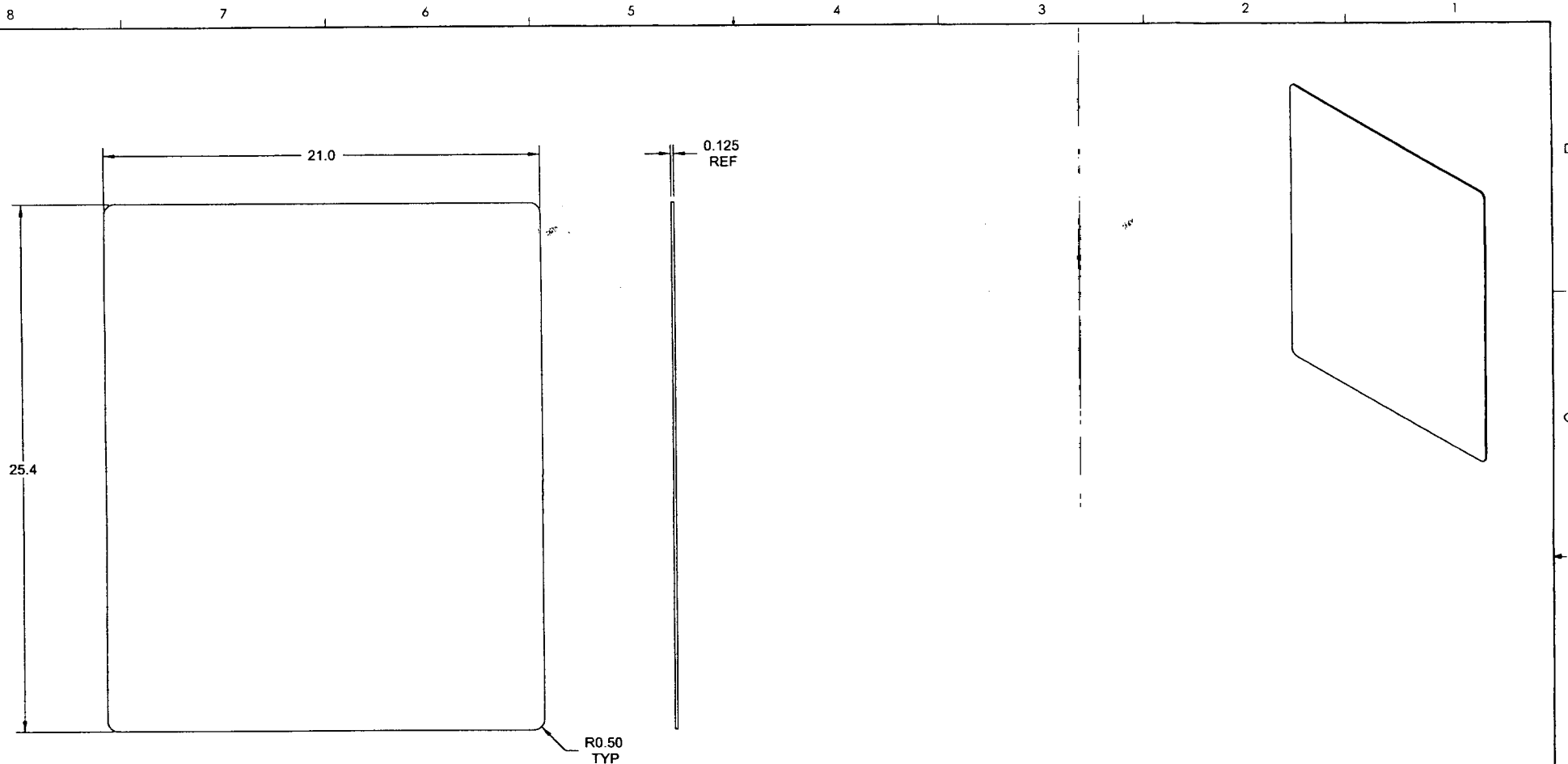
**D3891-2 PANEL**

**NOTES:**

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.77 lbs

**RELEASED**  
09/05/10

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DRAWN	gp	HAWKESBURY, ONTARIO, CANADA	
CHECKED	By	DRAWING NO.	REV. A
MFG. APPR.	W 16 54690	D3891	SHEET 4 OF 6
APPROVED	W 16 54690	TITLE	SCALE
DE APPR.	W 16 54690	PANEL, FWD	NTS
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**D3891-3 GASKET**

**NOTES:**

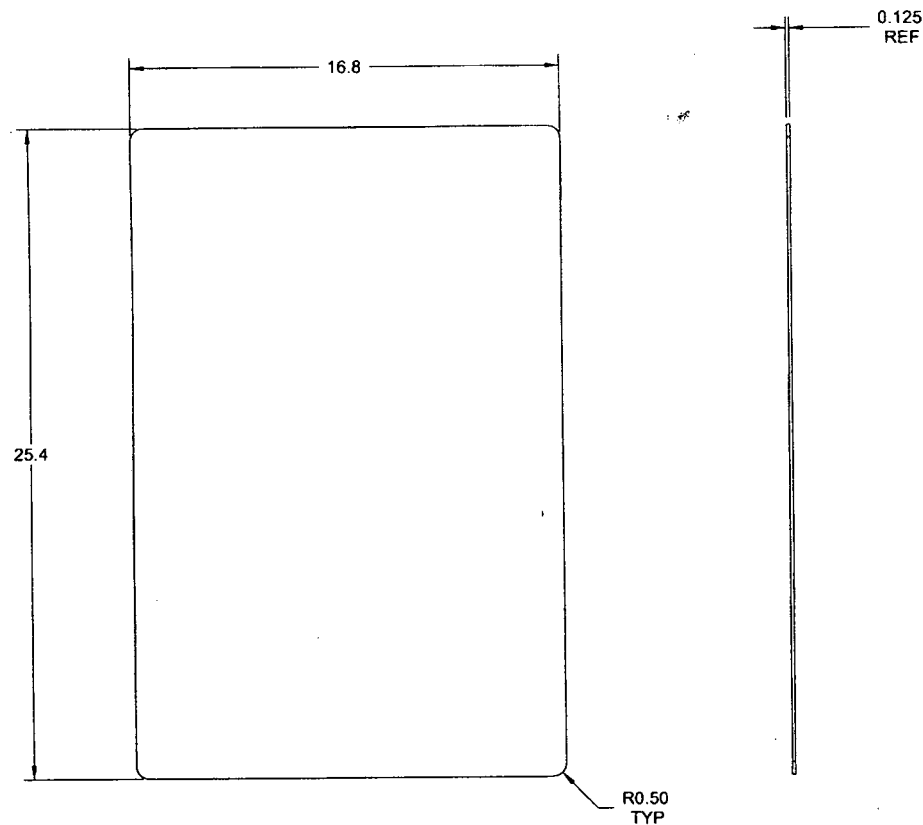
- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK  
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs

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09/05/01

W10 54690

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MFG. APPR.	92	D3891	SHEET 5 OF 6
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**D3891-4 GASKET**

**NOTES:**

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK  
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

**RELEASED**  
09/08/16-40

W10 34690

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